

Date: Tuesday, 6/19/2007 2:19:10 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BUSHING
Job Number : 32987
Estimate Number : 10725
P.O. Number : *N/A* Part Number : D2652
This Issue : 6/19/2007 S.O. No. : *N/A* Drawing Number : D2652 REV A
Prsht Rev. : NC Project Number : N/A
First Issue : *N/A* Type : MACHINED PARTS Drawing Revision : A
Previous Run : 32621 Material : *N/A*
Written By : Due Date : 7/10/2007 Qty: 200 Um: Each
Checked & Approved By : *02.06.20*
Comment : Est Rev.B 02.06.13 Now machined in house. NG

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M303R0500 303 Round Bar 0.500"



Comment: Qty.: 0.0578 f(s)/Unit Total : 11.5500 f(s) *5.4° 102447*

Material: 303 ss .500" Round Bar
(M303R0500)

Batch: *M102447*

8.5 / 12 07/07/05

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA250 & Dwg D2652

2-Deburr

8.5 / 12 07/07/05

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

8.5 / 12 07/07/05 *205*

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.F. 07/07/06

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.5 / 12 07/07/06 *205*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: / NCR: Yes ☒ No ☐ DQA: D Date: 10/10/9

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BUSHING

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Part Number: D2652

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



205

Comment: FINAL INSPECTION/W/O RELEASE

2067109

Job Completion



u 07.07.09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

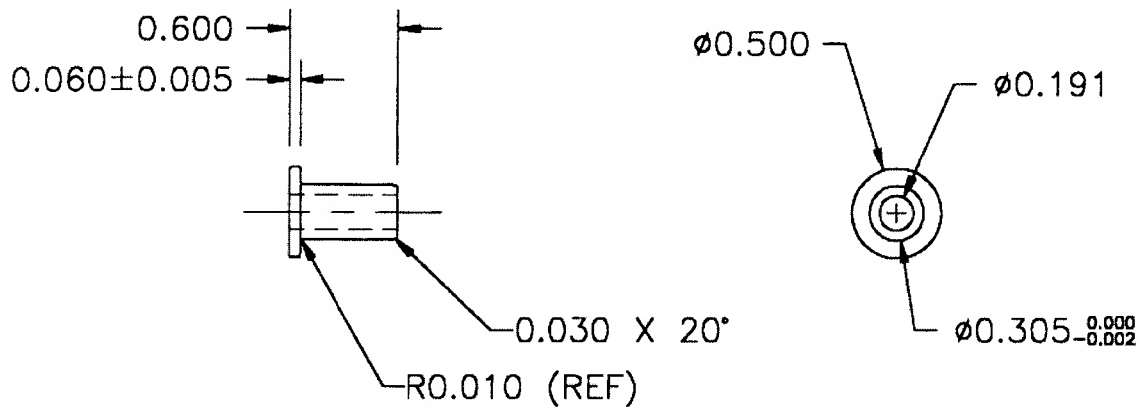
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2652	REV. A SHEET 1 OF 1
DATE 97:03:25		TITLE BUSHING	SCALE 1:1

RELEASED
97/04/25 DS



MATERIAL: AISI 303 SS

NOTE: BREAK ALL SHARP CORNERS 0.010 MAX

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32987